

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003879**Date Inspected:** 21-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Le Feng / Li Yang / An Qing			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** skin plates and stiffeners**Summary of Items Observed:****Tower Shop – Bay 1**

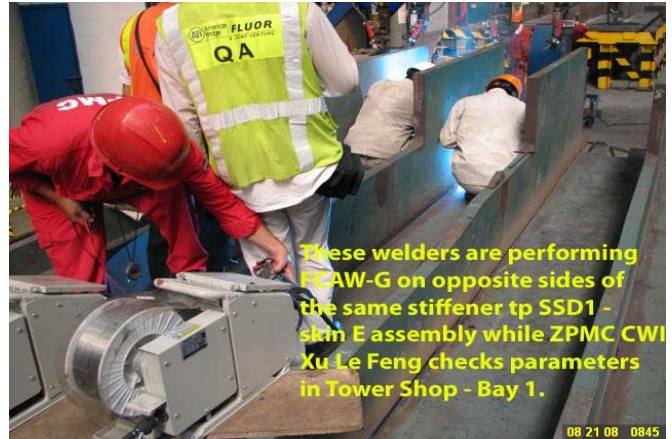
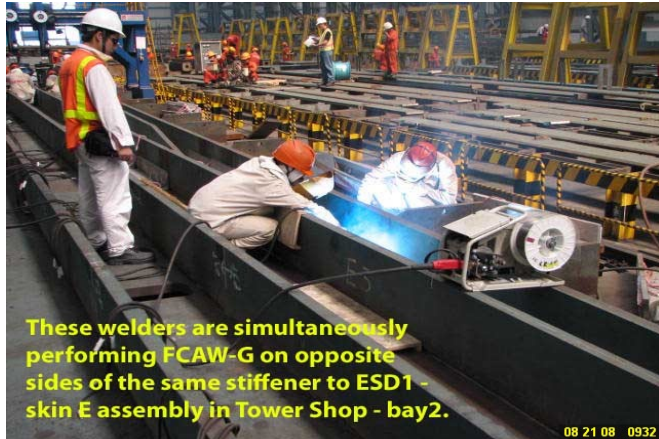
Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed approximately 70 ZPMC personnel performing the following: beginning of fit-up of stiffeners to SSD1 - skin C assembly - no welding yet; continue FCAW-G manual (2) and automatic from gantry (4) of fill passes of stiffeners to SSD1 - skin E assembly; ZPMC UT on cover passes of stiffeners to SSD1 - skin A assembly; SAW of skin stiffener butt welds. Also present in this bay were ZPMC CWI Xu Le Feng and ABF QC Jeff Chan. Items observed appeared to comply with project specifications.

Tower Shop – Bay 2

QA Inspector randomly observed approximately 40 ZPMC personnel performing the following: manual and automatic using gantry FCAW-G of stiffener to skin plate welds on ESD1 - skin E assembly; FCAW-G of stiffener to skin plate welds on ESD1 - skin B assembly. Also present in this bay were ZPMC CWI's Li Yang and An Qing Xiang as well as ABF QC's Xing Xiao Guang and Wu Gui Cai. Items observed appeared to comply with project specifications.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
